

## Release agent data sheet

### Code # W102

**Description:** A high production paste wax mold release with excellent breakdown characteristics for fast, even coverage. A firm carnauba based mold release paste wax blended with other synthetic waxes for use in various thermo-set composite molding applications

Properties	Unit	Value
Color		Off-white
Dry time at 22 °C	min	5 to 10 (will vary depending on working temp.)
Melting point	°C	85 to 93
Specific gravity	g / L (lbs / gal)	0.80 to 0.82 (approx. 6.75)

**Characteristics:**

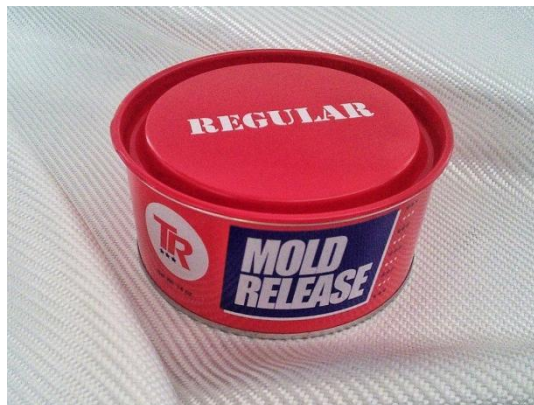
- High carnauba wax content polishes to high gloss without streaking
- Good heat and chemical resistance properties
- Easy application and wipe off characteristics
- Reduced wax build-up and styrene accumulation

**Use:** As a release agent for composite molding on all FRP tooling, metal and other hard surface molds. Suitable for open mold hand or spray lay-up, Resin Transfer/injection (RTM) & (RIM), Vacuum bag and compression molding and Polyester & epoxy resins.

Note: Check suitability when heat curing or higher temperature molding above 93 °C.

**Application:**

- On new or reconditioned tooling, suggest use sealer glaze W301 prior to waxing for added release, gloss and mold life.
- Apply wax with sponge applicator in thin even circular motion to the mold surface. Allow to haze dry (approx. 5-10 min) depending on ambient temperature and polish wipe to gloss finish with soft cloth (do not use microfiber cloth). For new or reconditioned molds, apply a minimum of 6 coats of paste wax, waiting approximately 30-60 minutes between applications for the wax to set & harden after the polish wipe. Best results are obtained, if after application, mold is allowed to stand overnight and a subsequent final coat of wax release applied the following day prior to gel coating.
- Follow with a coat of wax for the first 2-3 parts released.
- Then determine how many parts can be effectively produced before re-waxing is required. This will vary depending on molding condition, configuration, resin, mold cycles, effective cure of production gel coat and other factors.



Note: Technical information furnished is based on laboratory findings and believed to be correct. Since conditions of product use are outside our control, no warranties of any kind are made except that the materials supplied are of standard quality. All risks and liabilities arising from handling, storage and use of products, as well as compliance with applicable legal restrictions, rests with the user. In any case, all liability for damage or loss is only for the materials supplied by our company.

**SALES & ORDER PROCESSING**

28<sup>th</sup> of October St No 8A, 37300  
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